a dowel pin at the further end of the slot, by the set-screw in the block *F,* Fig. 21. As it is rather difficult to get the tongues on all the pieces exactly the correct width for a good fit in the slot, the latter is sometimes planed a little wider and the tongue is brought up against one side of the slot by set-screws. In the case in hand, a few thousandths inch clearance is provided in the slot, and the set-screw *G* in Fig. 22 is used for bringing the work against the further edge, which stands in correct relation to the holes to be drilled. The apron is held down against the bottom surface of the jig by four heavy set-screws *II.*

It will be noticed that the jig is open right through the sides in order to facilitate the finishing of the pads at the ends of the

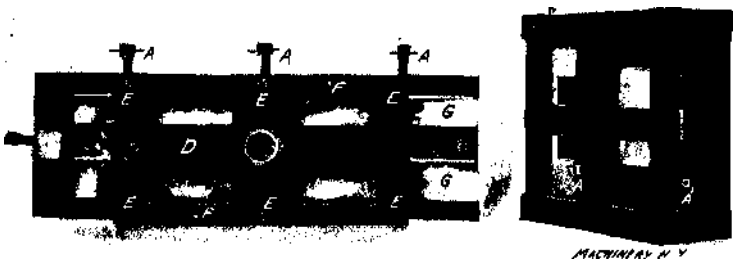


**Fig. 23. Jigs in which the Work is Located by Means of Beveled Surfaces**

work, and a swinging leaf, like the one previously described, reaches across one side for holding the lining and loose bushings for the hole *K* which is drilled and rose-reamed in the usual way. The large hole *V,* Fig. 21, is bored out with a special boring tool *M,* as there are no standard drills obtainable for this large size of hole. This special boring tool is guided by a cast-iron bushing which fits into the lining bushing; it is provided with two cutters, one for roughing and one for finishing. The small screw holes *0* around the large hole *V* are drilled from the bushing *P.* For drilling the rest of the holes, except the hole *Q,* stationary bushings are used. The screw holes ought to be drilled simultaneously in a multiple-spindle drill. The jig is provided with feet and cored out in convenient places in order